

Date: Friday, 17/08/2007 11:21:40 AM
 User: Linda Lacelle

Process Sheet

| | |
|--|---|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : TOP COVER |
| Job Number : 34095 | |
| Estimate Number : 12200 | |
| P.O. Number : N/A | Part Number : D346717 |
| This Issue : 17/08/2007 S.O. No. : N/A | Drawing Number : D3467 REV.B |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : N/A Type : SMALL /MED FAB | Drawing Revision : B |
| Previous Run : 28582 | Material : N/A |
| Written By : <u>[Signature]</u> | Due Date : 11/09/2007 Qty: 10 Um: Each |
| Checked & Approved By : <u>[Signature]</u> | |
| Comment : est rev. 06.04.20 new issue EC Est Rev:B As per Rev B 06-05-24 JLM | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|-----------|---------------------|
| 1.0 | M304S26GA | 304/316 0.018 SHEET |
|-----|-----------|---------------------|



Comment: Qty.: 1.0973 sf(s)/Unit Total : 10.9725 sf(s)
 304/316 0.018 SHEET batch: M105445

SAP 07/08/30

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET
 Cut as per Dwg D3467
 Dwg Rev: B
 Prog Rev: B

SAP 07/08/30

10

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAP 07/08/30

10

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

Er 07/08/30

counted
(X10)

| | | |
|-----|-------------|-------------------------------|
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1
 1-Deburr

2-Bend as per dwg D3467

SAP 07/09/06 (10)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: DP Date: 07/09/10
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 17/08/2007 11:21:40 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOP COVER

Job Number: 34095

Part Number: D346717

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

count
En 07/09/06 *(10)*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location *GA*

SB 07/09/06 *(10)*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(10)
D 07/09/10

Job Completion



U 07-09-07

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

| | | | |
|-------------------------------------|--|---------------------|----------|
| DART AEROSPACE LTD | | Work Order: | 34095 |
| Description: Top Cover | | Part Number: | D3467-17 |
| Inspection Dwg: D3467 Rev: B | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

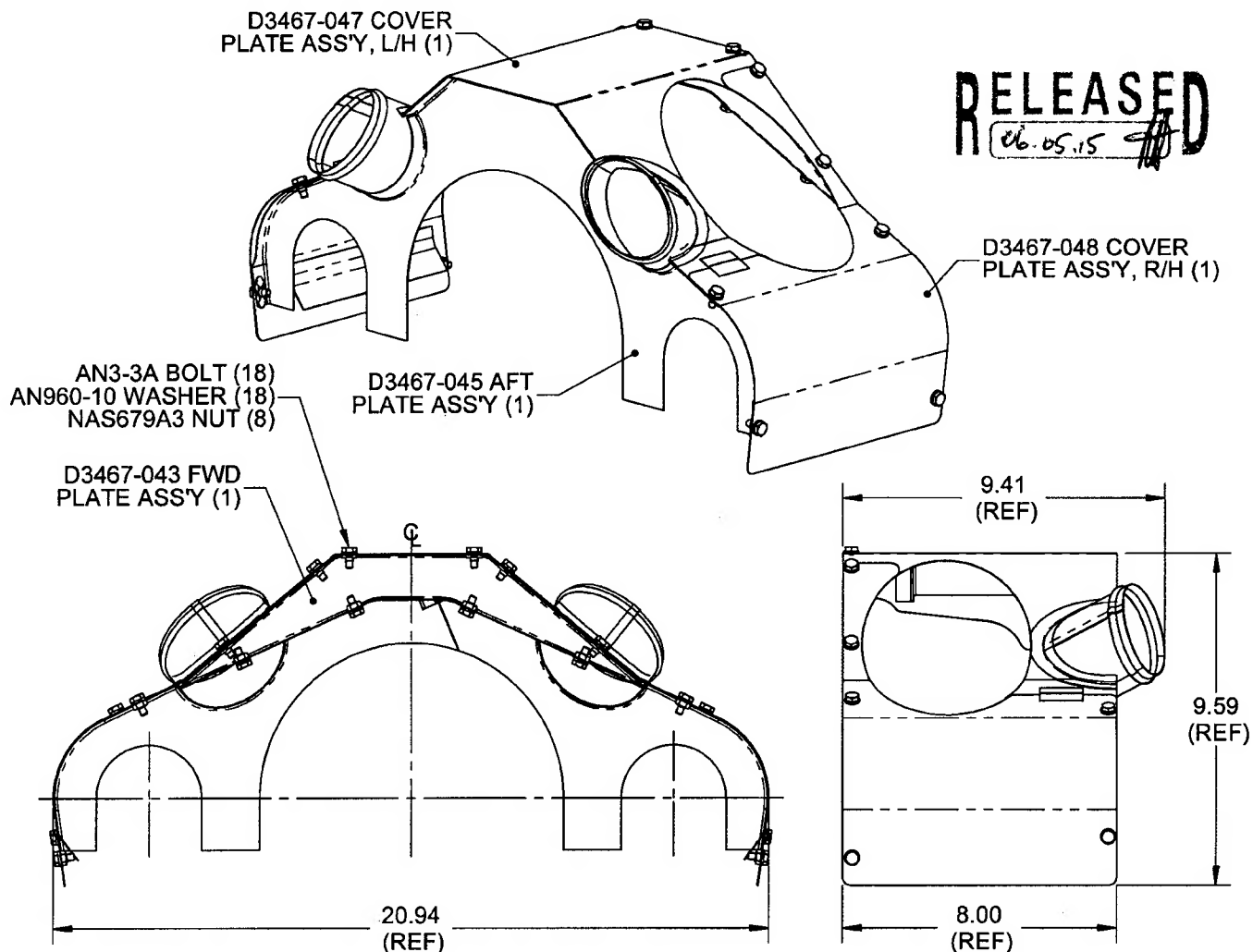
| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 18.76 | +/-0.030 | 18.75 | ✓ | | M-T | |
| Ø0.250 | +0.005/-0.001 | Ø0.250 | ✓ | | Vern | |
| 8.00 | +/-0.030 | 7.995 | ✓ | | Vern | |
| 3.530 | +/-0.010 | 3.532 | ✓ | | Vern | |
| 9.379 | +/-0.010 | 9.380 | ✓ | | M-T/Vern | |
| 6.476 | +/-0.010 | 6.471 | ✓ | | Vern | |
| 0.280 | +/-0.010 | 0.277 | ✓ | | Vern | |
| 3.251 | +/-0.010 | 3.251 | ✓ | | ✓ Vern | |
| 2.951 | +/-0.010 | 2.950 | ✓ | | Vern | |
| 1.844 | +/-0.010 | 1.840 | ✓ | | Vern | |
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|---------------------|----------|--------------------|----------|----------------------------|-----|
| Measured by: | SAD | Audited by: | En | Prototype Approval: | N/A |
| Date: | 07/08/30 | Date: | 07/08/30 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 06.10.27 | New Issue | KJ/JLM | |

DART

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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3467 | REV. B SHEET 1 OF 15 |
| DATE 06.05.15 | | TITLE SHROUD ASSEMBLY | SCALE 1:5 |
| A | 05.12.07 | NEW ISSUE | |
| B | 06.05.15 | Ø0.250 & Ø0.203 WERE Ø0.194 ; UPDATED D3467-9F/-15F | |

**D3467-041 SHROUD ASSEMBLY****NOTES:**

- 1) IDENTIFY WITH DART P/N D3467-041 USING FINE POINT PERMANENT INK MARKER
- 2) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

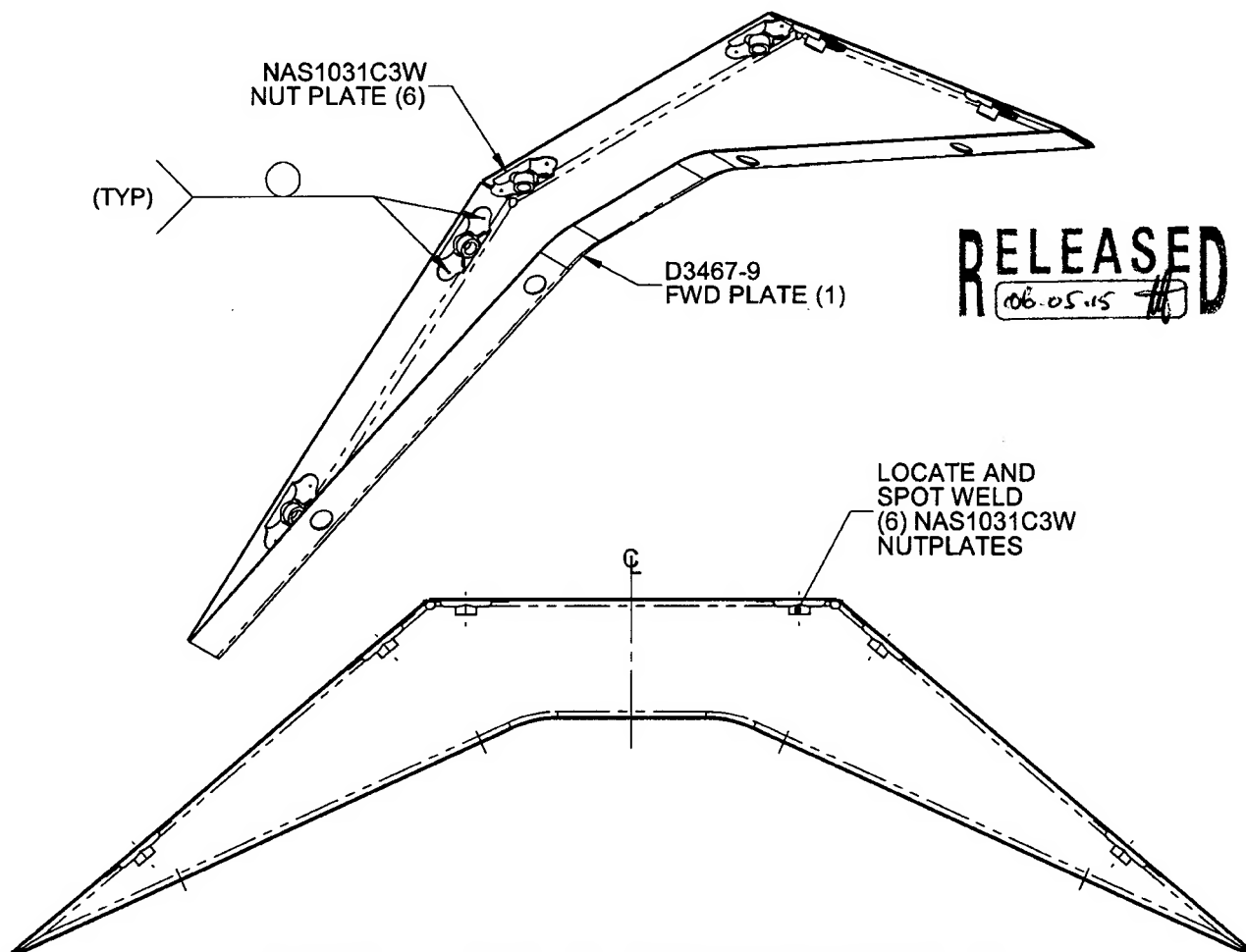
| QTY -041 | P/N | DESCRIPTION |
|-------------|-----------|---------------------------|
| X | D3467-041 | SHROUD ASSEMBLY |
| 1 | D3467-043 | FWD PLATE ASSEMBLY |
| 1 | D3467-045 | AFT PLATE ASSEMBLY |
| 1 | D3467-047 | COVER PLATE ASSEMBLY, L/H |
| 1 | D3467-048 | COVER PLATE ASSEMBLY, R/H |
| 18 | AN3-3A | BOLT |
| 18 | AN960-10 | WASHER |
| 8 | NAS679A3 | NUT |

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| DATE 06.05.15 | | TITLE SHROUD ASSEMBLY | SCALE 1:2 |



| QTY -043 | P/N | DESCRIPTION |
|-------------|------------|--------------------|
| X | D3467-043 | FWD PLATE ASSEMBLY |
| 1 | D3467-9 | FWD PLATE |
| 6 | NAS1031C3W | NUT PLATE |

D3467-043 FWD PLATE ASSEMBLY

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) ASSEMBLY IS SYMETRICAL ABOUT CENTER LINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WITHOUT NOTICE
WORK ORDER
NO. 34095

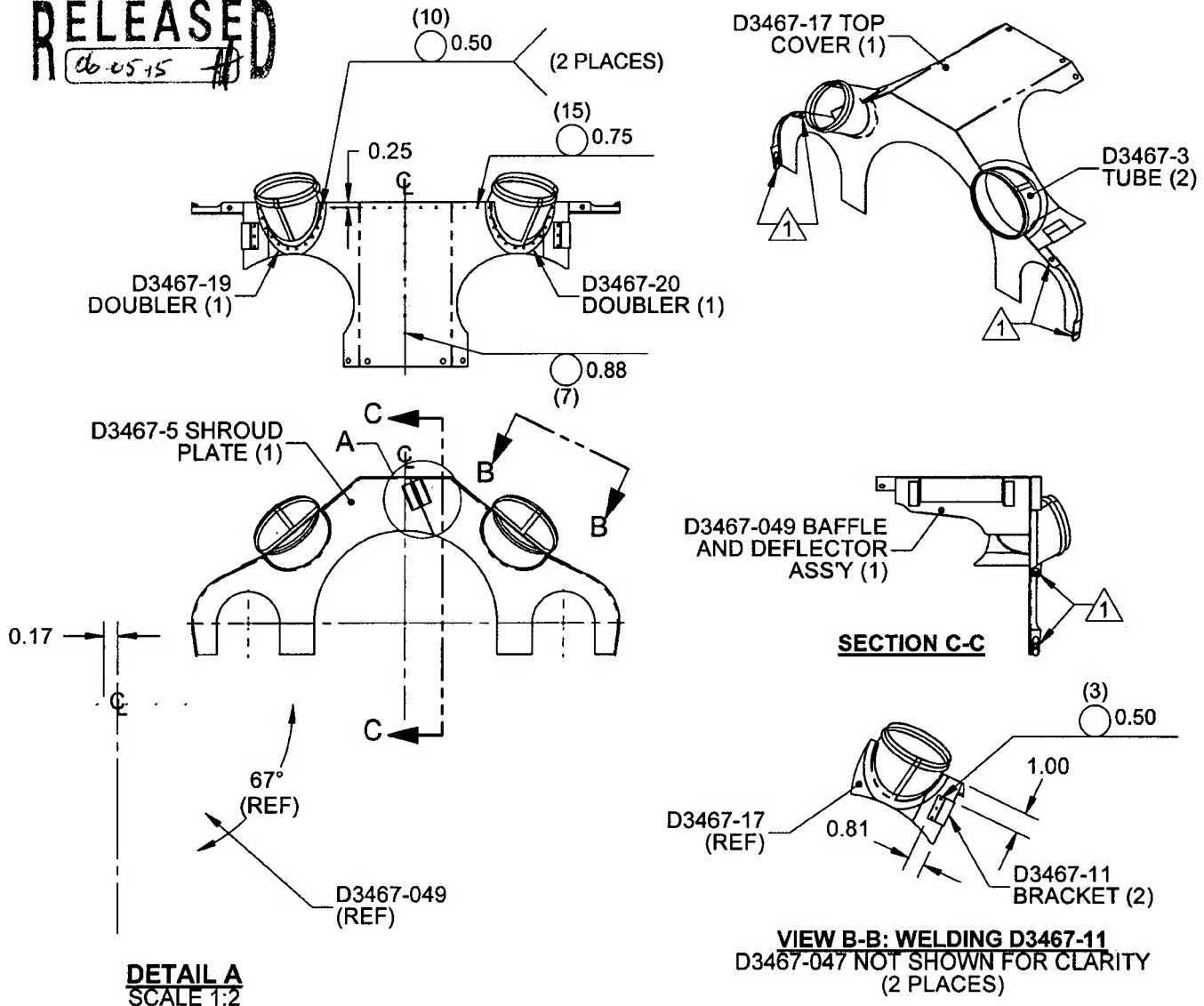
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| DATE 06.05.15 | | TITLE SHROUD ASSEMBLY | SCALE 1:8 |

RELEASED
06-05-15



D3467-045 AFT PLATE ASSEMBLY

NOTES:

- 1) LOCATE AND SPOT WELD NAS1031C3W NUTPLATE (4) TO D3467-5 PRIOR WELDING OTHER PARTS TO D3467-5
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

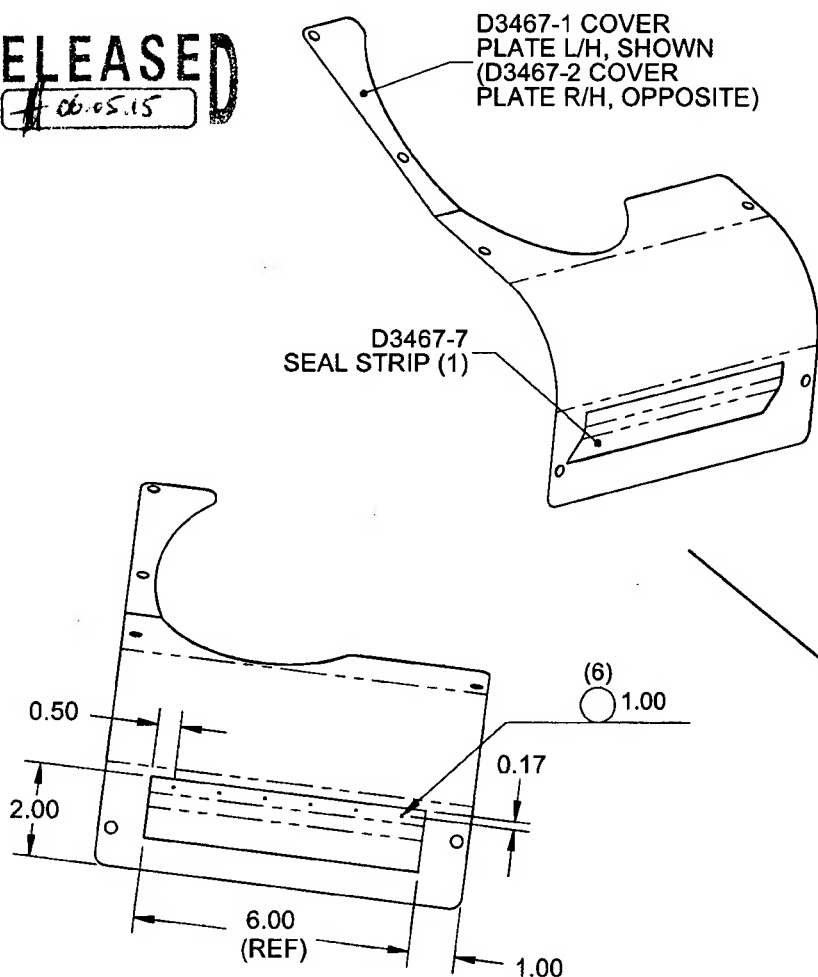
| QTY -045 | P/N | DESCRIPTION |
|-------------|------------|-----------------------------------|
| X | D3467-045 | AFT PLATE ASSEMBLY |
| 1 | D3467-049 | BAFFLE AND DEFLECTOR ASSEMBLY |
| 2 | D3467-3 | TUBE SHOP COPY |
| 1 | D3467-5 | SHROUD PLATE RETURN TO |
| 2 | D3467-11 | BRACKET ENGINEERING |
| 1 | D3467-17 | TOP COVER UNCONTROLLED COPY |
| 1 | D3467-19 | DOUBLER SUBJECT TO AMENDMENT |
| 1 | D3467-20 | DOUBLER WITHOUT NOTICE |
| 4 | NAS1031C3W | NUT PLATE WORK ORDER NO. 34095 |

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| DATE 06.05.15 | | TITLE SHROUD ASSEMBLY | SCALE 1:4 |

RELEASED
#06.05.15

D3467-047 COVER PLATE ASS'Y L/H, SHOWN
D3467-048 COVER PLATE ASS'Y R/H, OPPOSITE

30° TOP COPY
(REF) TURN TO
ENGINEERING
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WITHOUT NOTICE

NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO
0.010

| QTY -047 | QTY -048 | P/N | DESCRIPTION |
|-------------|-------------|-----------|---------------------------|
| X | | D3467-047 | COVER PLATE ASSEMBLY, L/H |
| | X | D3467-048 | COVER PLATE ASSEMBLY, R/H |
| 1 | | D3467-1 | COVER PLATE, L/H |
| | 1 | D3467-2 | COVER PLATE, R/H |
| 1 | 1 | D3467-7 | SEAL STRIP |

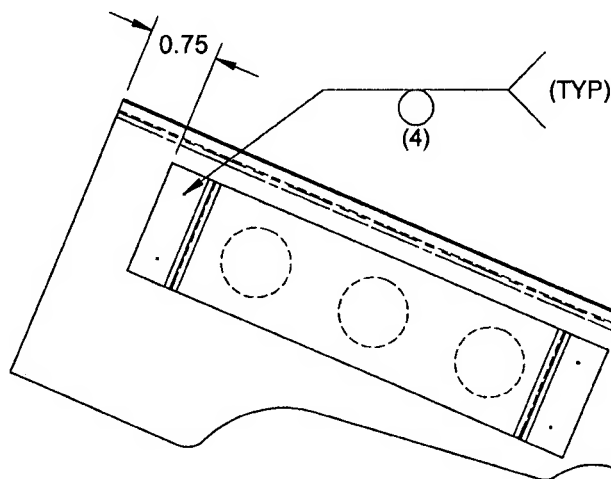
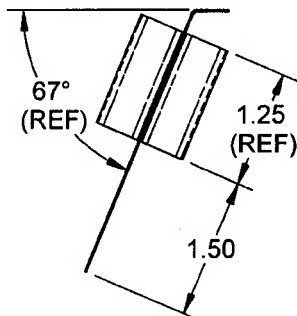
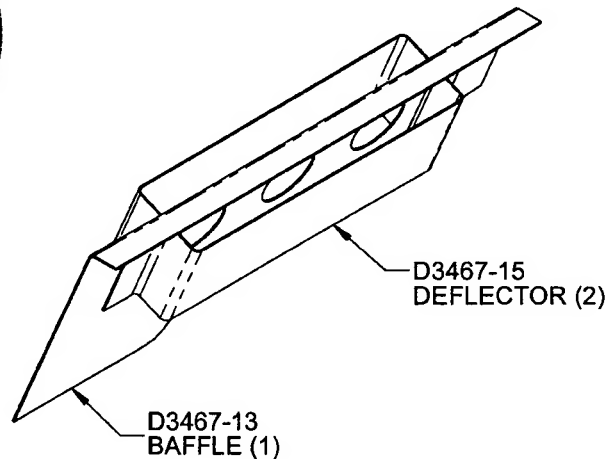
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| DATE 06.05.15 | | TITLE SHROUD ASSEMBLY | SCALE 1:2 |

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[Signature] 06.05.15



D3467-049 BAFFLE & DEFLECTOR ASSEMBLY

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WORK ORDER
NO. *34095*

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

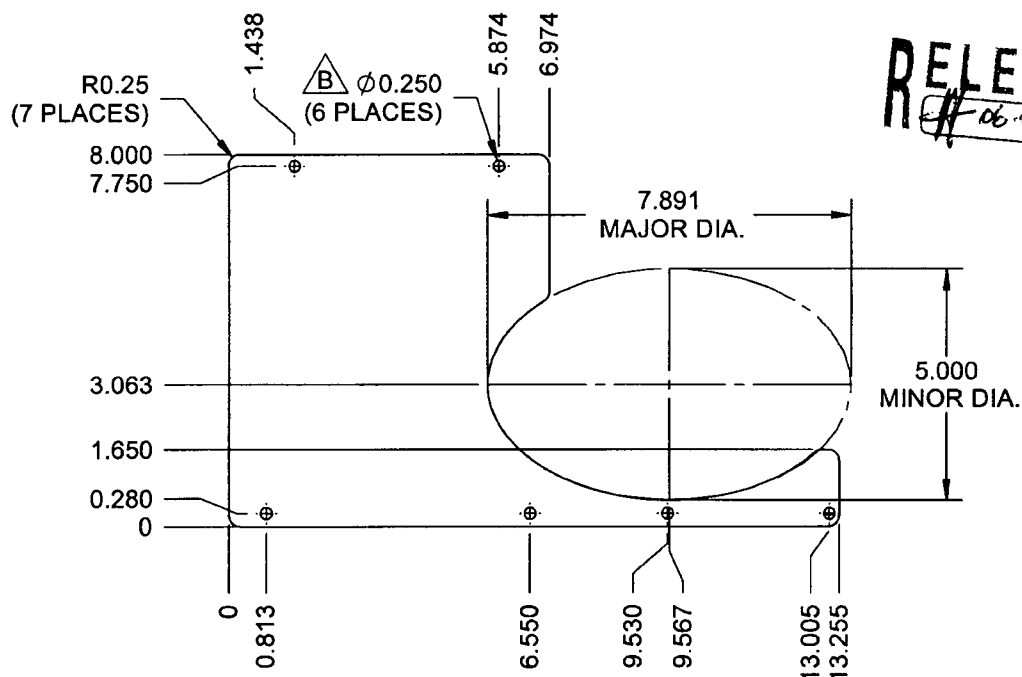
| QTY -049 | P/N | DESCRIPTION |
|-------------|-----------|-----------------------------|
| | D3467-049 | BAFFLE & DEFLECTOR ASSEMBLY |
| 1 | D3467-13 | BAFFLE |
| 2 | D3467-15 | DEFLECTOR |

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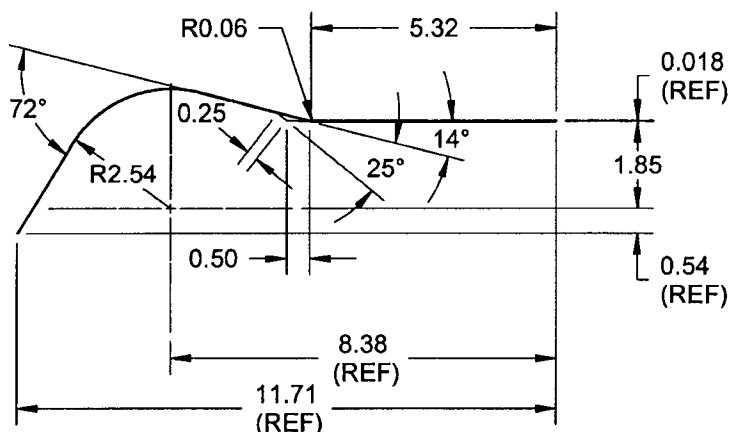
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| DATE 06.05.15 | | TITLE SHROUD ASSEMBLY | SCALE 1:4 |



D3467-1F COVER PLATE FLAT PATTERN



D3467-1 L/H COVER PLATE ISOMETRIC VIEW

D3467-2 R/H COVER PLATE (OPPOSITE)

SCALE 1:8

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER
NO. 34095

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

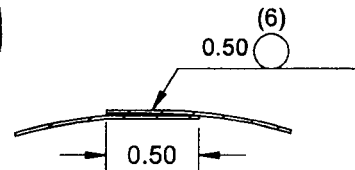
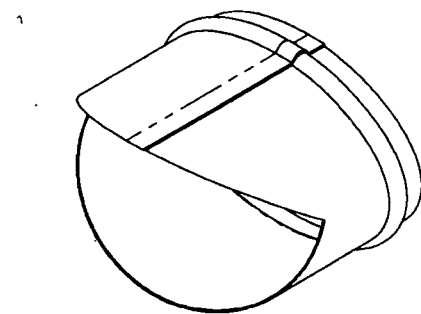
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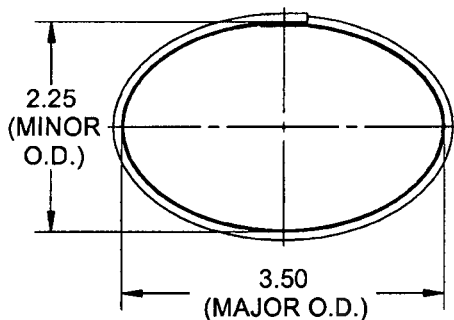


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| DESIGN <i>B</i> | DRAWN BY <i>B</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
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| DATE 06.05.15 | | TITLE SHROUD ASSEMBLY | SCALE 1:2 |

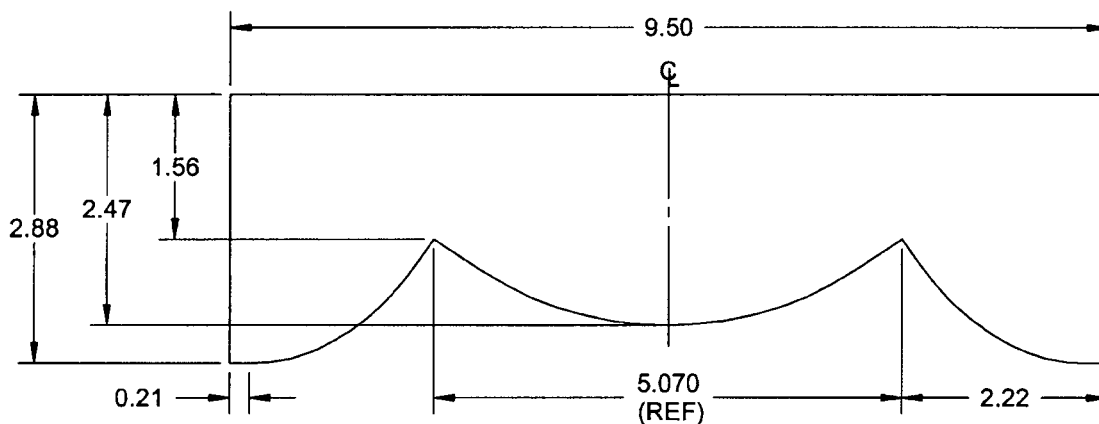
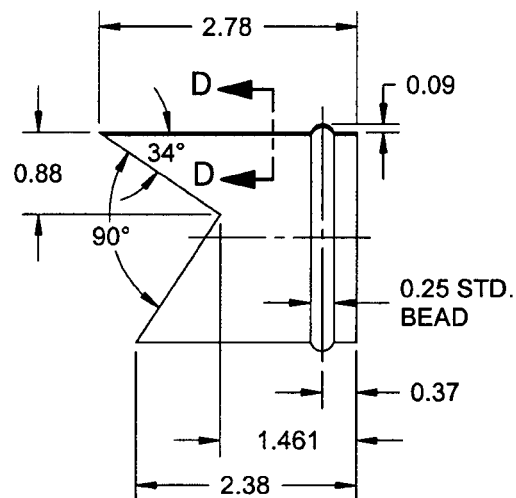
RELEASED
06.05.15



SECTION D-D
SCALE 1:1



D3467-3 TUBE DETAIL



D3467-3F TUBE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 3) SPOT WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

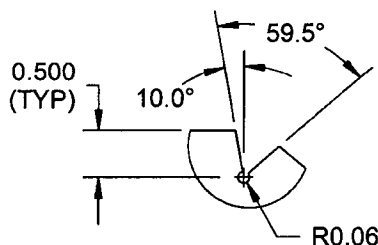
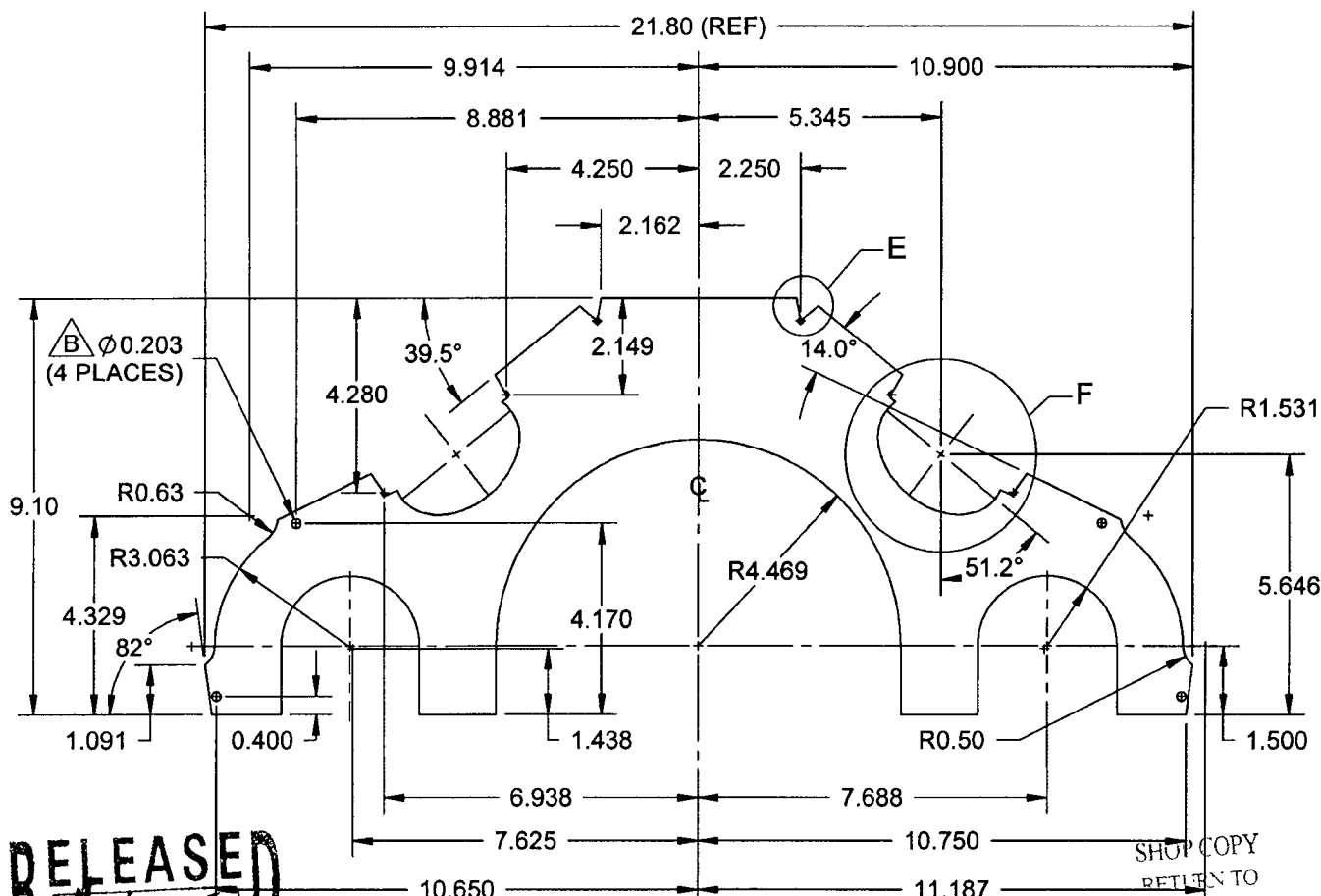
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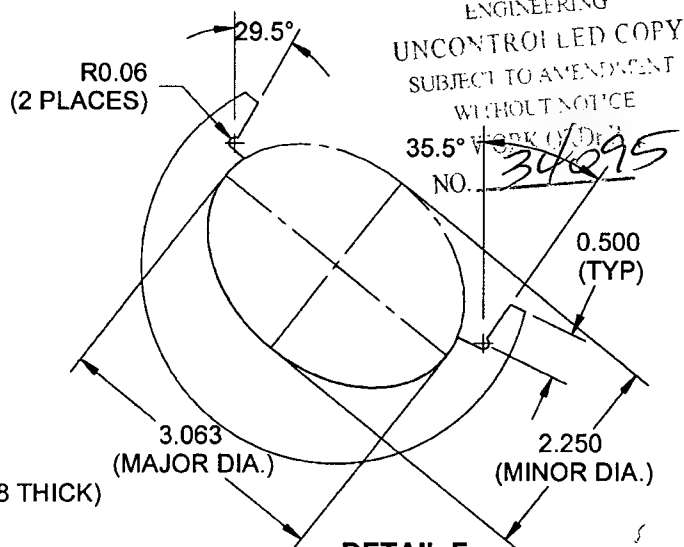
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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3467 REV. B SHEET 8 OF 15 |
| DATE 06.05.15 | TITLE SHROUD ASSEMBLY | SCALE 1:8 |



DETAIL E
SCALE 1:2



DETAIL F
SCALE 1:2

D3467-5F AFT PLATE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019
(ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

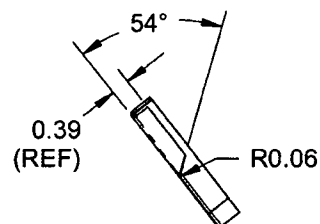
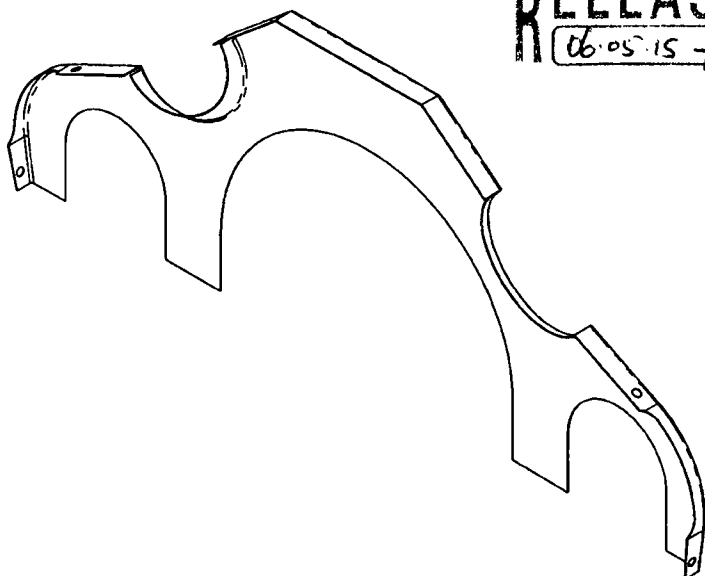
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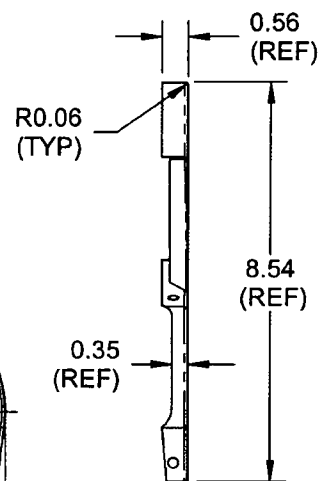
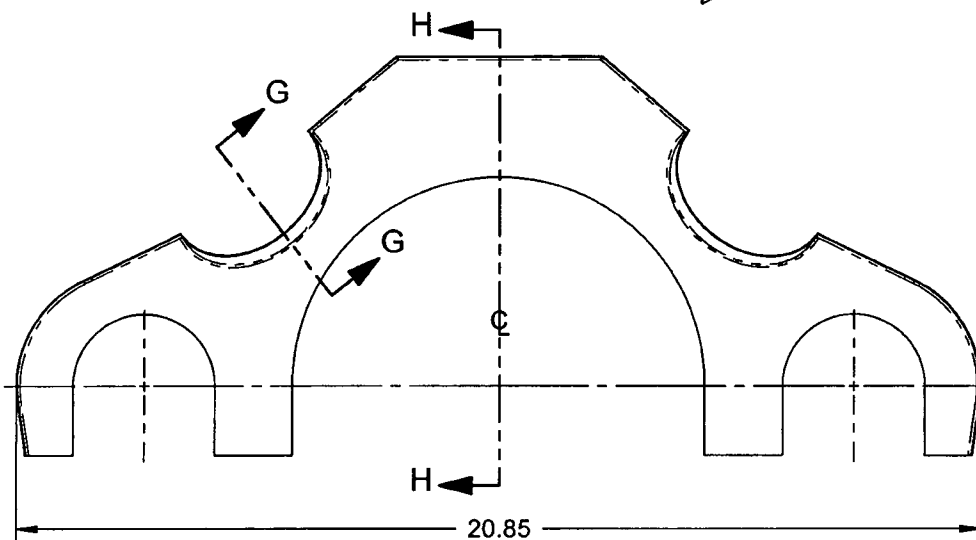


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| CHECKED 13 | APPROVED 13 | DRAWING NO. D3467 | REV. B SHEET 9 OF 15 |
| DATE 06.05.15 | | TITLE SHROUD ASSEMBLY | SCALE 1:4 |

RELEASED
06.05.15



SECTION G-G



SECTION H-H

D3467-5 AFT PLATE BENDING DETAIL

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

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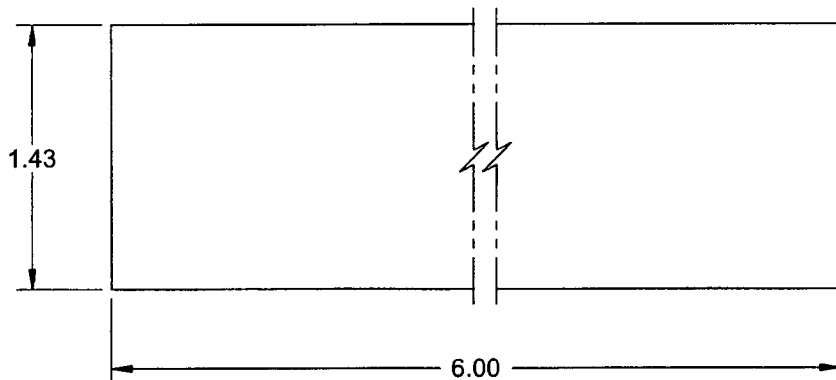
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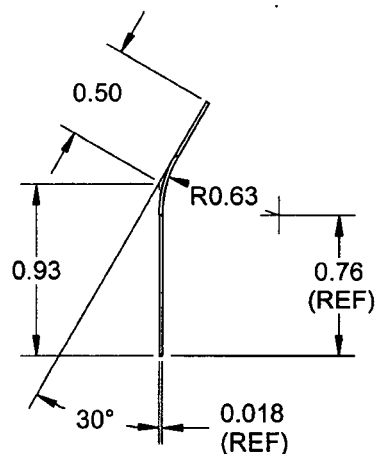


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| DATE 06.05.15 | | TITLE SHROUD ASSEMBLY | SCALE 1:1 |

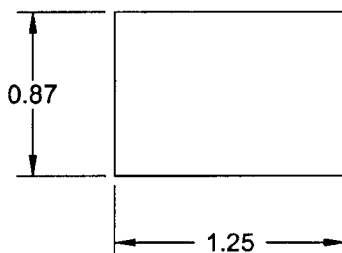
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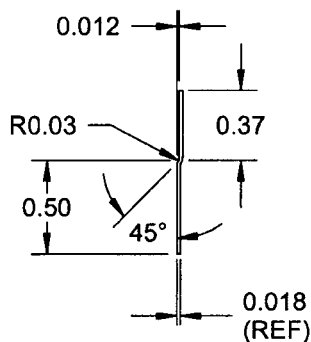
D3467-7F SEAL STRIP
FLAT PATTERN



D3467-7 SEAL STRIP
BENDING DETAIL



D3467-11F BRACKET
FLAT PATTERN



D3467-11 BRACKET
JOGGLE DETAIL

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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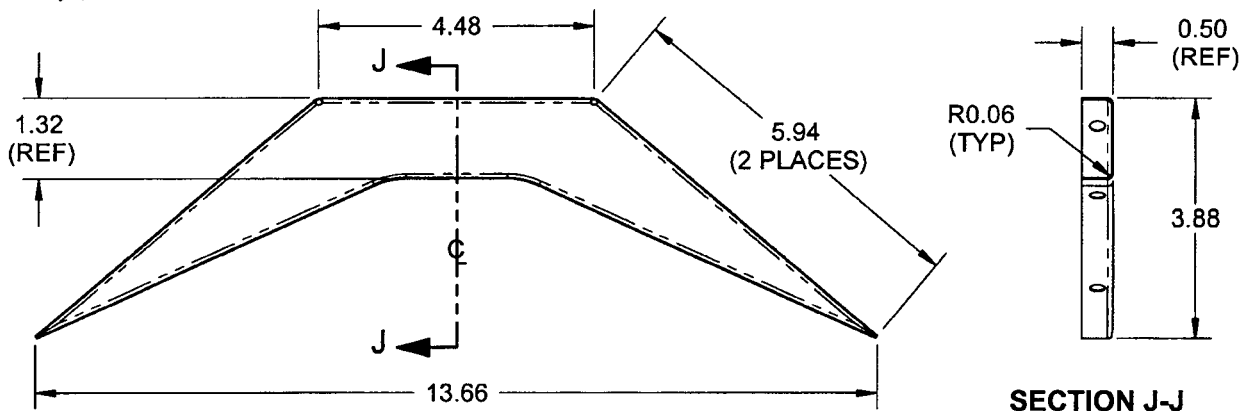
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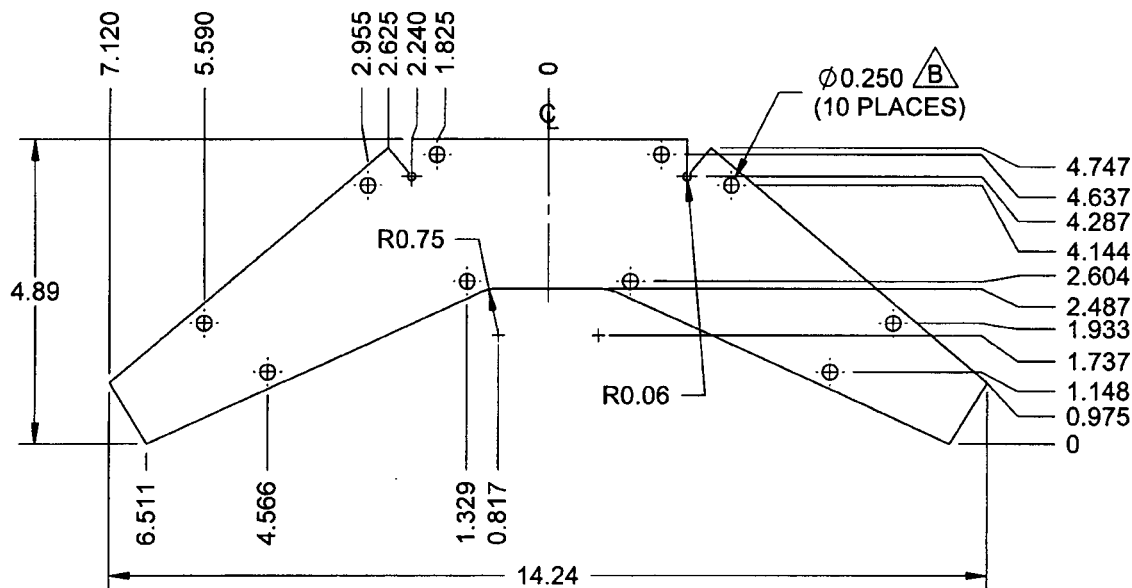


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| DATE 06.05.15 | | TITLE SHROUD ASSEMBLY | SCALE 1:3 |

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06.05.15



D3467-9 FWD PLATE BENDING DETAIL



D3467-9F FWD PLATE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 26 FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTER LINE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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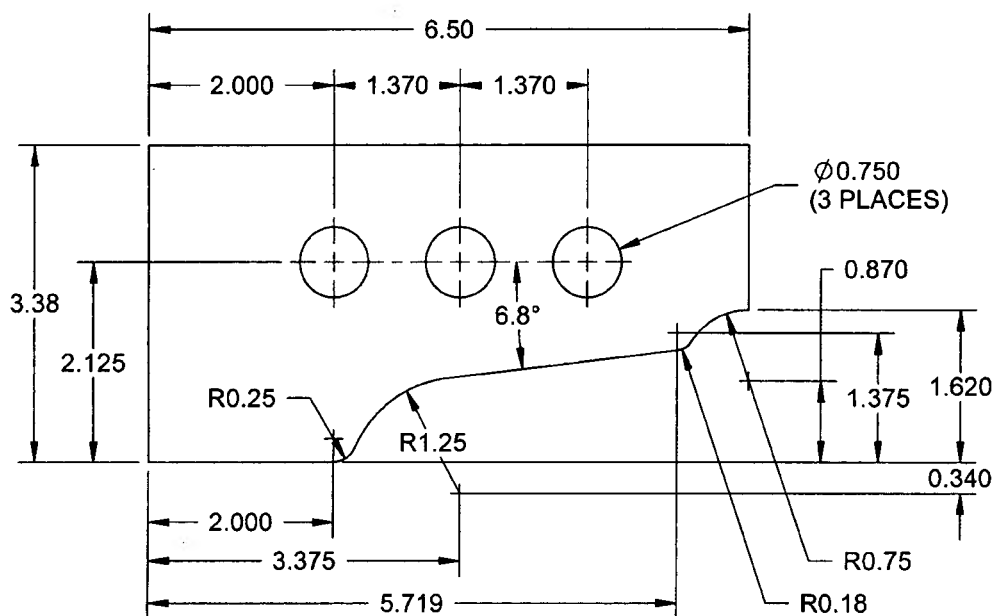
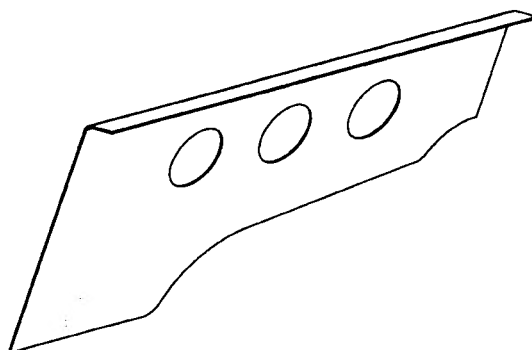
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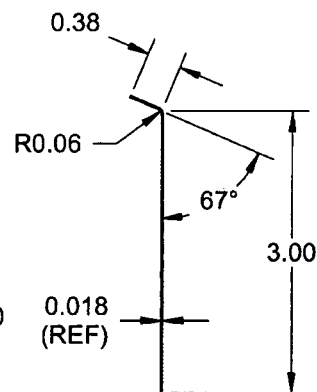


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| DATE 06.05.15 | | TITLE SHROUD ASSEMBLY | SCALE 1:2 |

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**D3467-13F BAFFLE
FLAT PATTERN**



**D3467-13 BAFFLE
BEND DETAIL**

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH LED COPY
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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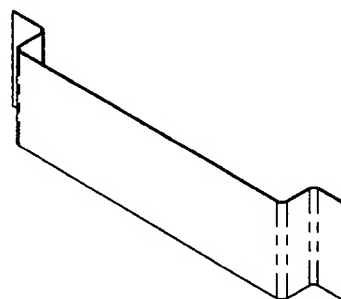
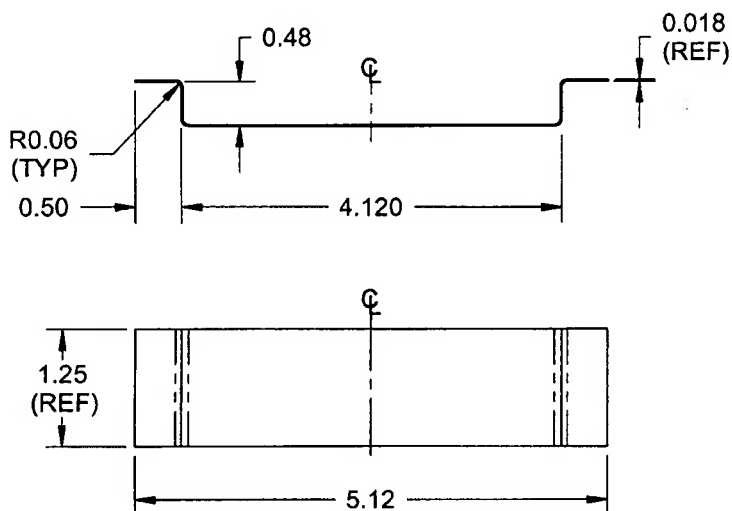
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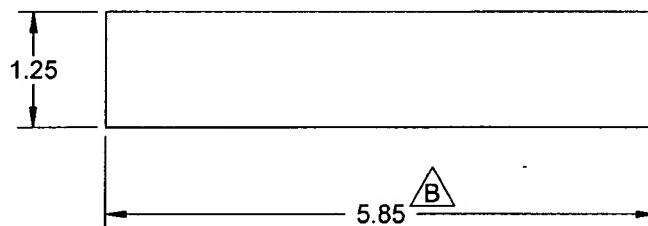


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| DATE 06.05.15 | | TITLE SHROUD ASSEMBLY | SCALE 1:2 |

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D3467-15 DEFLECTOR BENDING DETAIL



D3467-15F DEFLECTOR FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

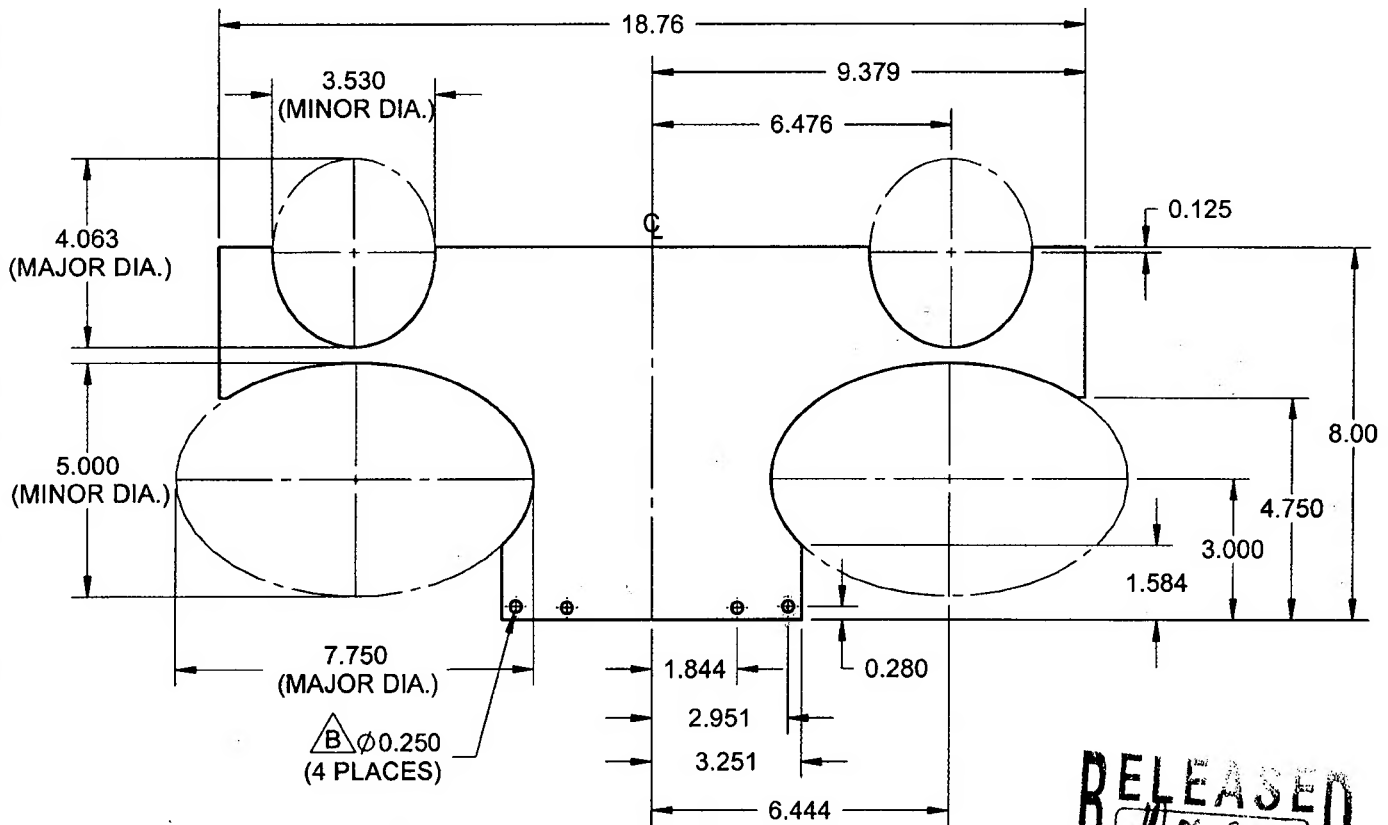
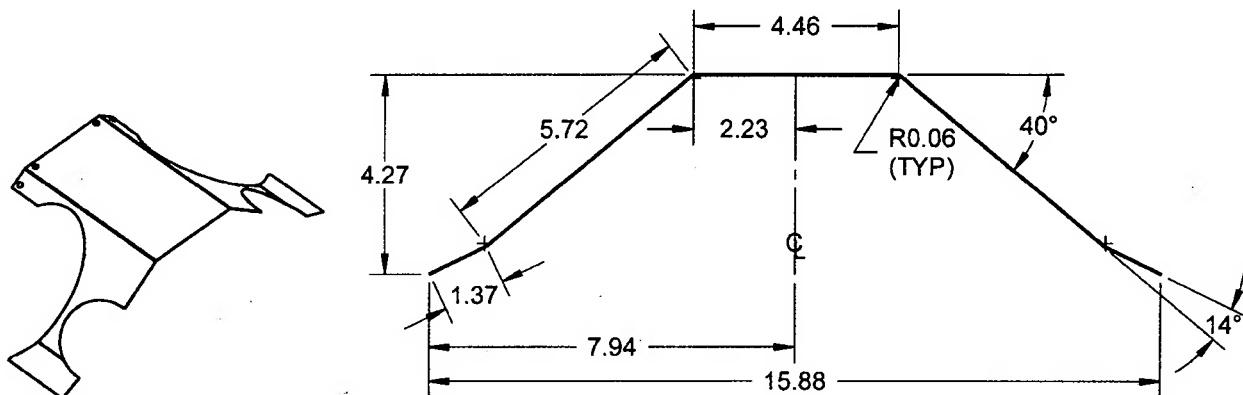
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| DATE 06.05.15 | | TITLE SHROUD ASSEMBLY | SCALE 1:4 |

**D3467-17F TOP COVER FLAT PATTERN****RELEASED**
#06-05-15**D3467-17 TOP COVER BENDING DETAIL****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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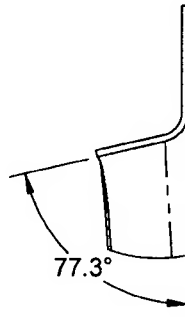
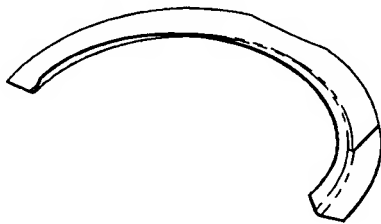
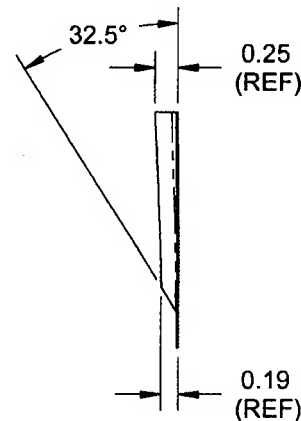
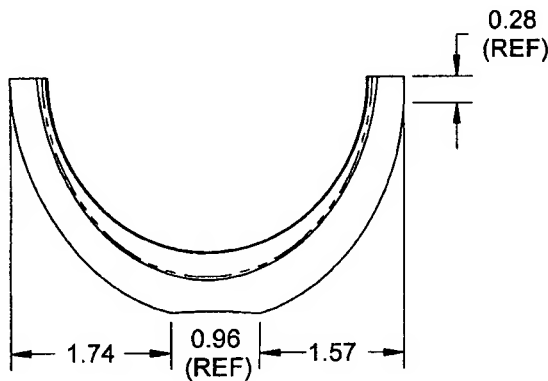
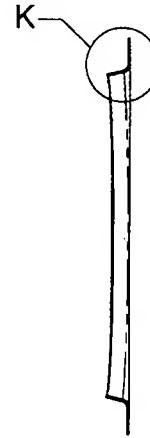
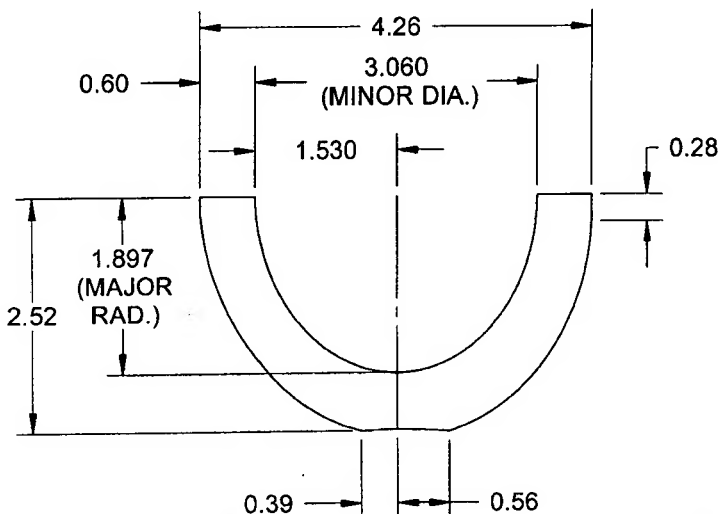
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| DATE 06.05.15 | | TITLE SHROUD ASSEMBLY | SCALE 1:2 |

RELEASED
06 vs 15**DETAIL K**
SCALE 1:2**D3467-19 DOUBLER, L/H SHOWN**
D3467-20 DOUBLER, R/H OPPOSITESHOP COPY
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WITHOUT NOTICE
WORK ORDER**D3467-19F FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS ^{SHOP COPY} PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA) COPY
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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